

Work Order ID 129171

Friday, January 30, 2015 8:52:07 AM

129171 Ship Feb 13

Page 1

Item ID: D412-698-111

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 1/30/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/30/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 15-01-30 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9635

B

5.0

0.00

100

Document Control

DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-698-111 CHG002

2x

DAS
46
9-89

FEB 12 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

DAS
66
9-89

JAN 31 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

2x

DAS
46
9-89

FEB 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129171

Friday, January 30, 2015 8:52:07 AM

129171

Page 2

Item ID: D412-698-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 1/30/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/30/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-111
Location: *Ship 034**2*
DAS
06
9-39

FEB 13 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*5/15/13**AP 5.2-13*

DQA: _____ Date: _____



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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 30, 2015 8:52:11 AM

Page 1

Work Order ID: 129171

129171

Parent Item: D412-698-111

D412-698-111

Parent Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.11.29 NEW ISSUE DD VERF:JLM
13.01.22 ECN13-516 NOW @ CHG 002 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3121-141		Manufactured	No				Each	7.0000		6			DAS 06 9-89
-----------	--	--------------	----	--	--	--	------	--------	--	---	--	--	-------------------

2 *D3121-141*
Bracket Assembly
DAS
46
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST019	7	
-------	---	--

D3121-143		Manufactured	No				Each	5.0000		2			DAS 06 9-89
-----------	--	--------------	----	--	--	--	------	--------	--	---	--	--	-------------------

2 *D3121-143*
Bracket Assembly
DAS
46
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST019	5	
-------	---	--

D3199-1		Manufactured	No				Each	89.0000		16			DAS 06 9-89
---------	--	--------------	----	--	--	--	------	---------	--	----	--	--	-------------------

2 *D3199-1*
Bracket
DAS
46
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST026	44	
-------	----	--

D3202-1		Manufactured	No				Each	13.0000		2			DAS 06 9-89
---------	--	--------------	----	--	--	--	------	---------	--	---	--	--	-------------------

2 *D3202-1*
Cover
DAS
46
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST195a	13	
--------	----	--

117194

JAN 31 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 30, 2015 8:52:11 AM

Work Order ID: 129171

Parent Item: D412-698-111

Parent Item Name: Cabin Door Roller LH Aluminum Door

129171

D412-698-111

D4737-041

DAS

Manufactured

No

~ *D4737-041*

Bracket Assembly

D4737-043

Manufactured

No

~ *D4737-043*

Bracket Assembly

DAS

46

9-89

D3199.3

Just
15-02-12

DAS

46

9-89

2x 77361
1x
each

Each 0.0000

Each 0.0000

Start Date: 1/30/2015

Start Qty: 2.00

Required Date: 1/30/2015

Required Qty: 2.00

** BTD 9.173 2

** 2

FEB 12 2015

BTD 9.173 2

FEB 12 2015

DAS
46
9-89

DAS
46
9-89

DAS
46
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E & INSTRUCTIONS FOR
CONTINUED AIRWORTHINESS ICA-D412-698 REV. 5

REF. TCCA STC SH92-43

REF. FAA STC SR01446NY

REF. EASA STC EASA.IM.R.S.00709

1.0 PURPOSE

The purpose of this service instruction is to add the D412-698-111/-112 Cabin Door Roller kits for installation on aircraft equipped with cargo door assembly P/N's 205-031-669-15 (LH) and 205-031-669-16 (RH). Customers who have purchased the D412-698-011/-012 kits can upgrade to D412-698-111/-112 using the DSI 9635-011/-012 kits as follows:

- DSI 9635-011 Roller Bracket Change Kit, LH: converts a D412-698-011 to a D412-698-111;
- DSI 9635-012 Roller Bracket Change Kit, RH: converts a D412-698-012 to a D412-698-112.

2.0 PARTS LISTS

Qty -011	Qty -012	Part Number	Description
X		DSI 9635-011	ROLLER BRACKET CHANGE KIT, LH (TO CONVERT A D412-698-011 KIT)
	X	DSI 9635-012	ROLLER BRACKET CHANGE KIT, RH (TO CONVERT A D412-698-012 KIT)
1		D3199-3	FORWARD BRACKET, LH
	1	D3199-4	FORWARD BRACKET, RH
1	1	D4737-041	BRACKET ASSEMBLY
1		D4737-043	BRACKET ASSEMBLY
	1	D4737-044	BRACKET ASSEMBLY

Qty -111	Qty -112	Part Number	Description
X		D412-698-111	CABIN DOOR ROLLER KIT, LH
	X	D412-698-112	CABIN DOOR ROLLER KIT, RH
3	3	D3121-141	BRACKET ASSEMBLY
1		D3121-143	BRACKET ASSEMBLY
	1	D3121-144	BRACKET ASSEMBLY
8	8	D3199-1	BRACKET
1		D3199-3	FORWARD BRACKET, LH
	1	D3199-4	FORWARD BRACKET, RH
1	1	D3202-1	COVER
1	1	D4737-041	BRACKET ASSEMBLY
1		D4737-043	BRACKET ASSEMBLY
	1	D4737-044	BRACKET ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 13.01.11

CERT. NO.: SH92-43

ISSUE NO.: 5

B	ADD D3199-3/-4 TO KITS	MB	13.01.09
A	NEW ISSUE	MB	12.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	NA	DSI 9635	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ROLLER BRACKET CHANGE KIT	NTS
DATE	13.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

15-01-30
129171 MJS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

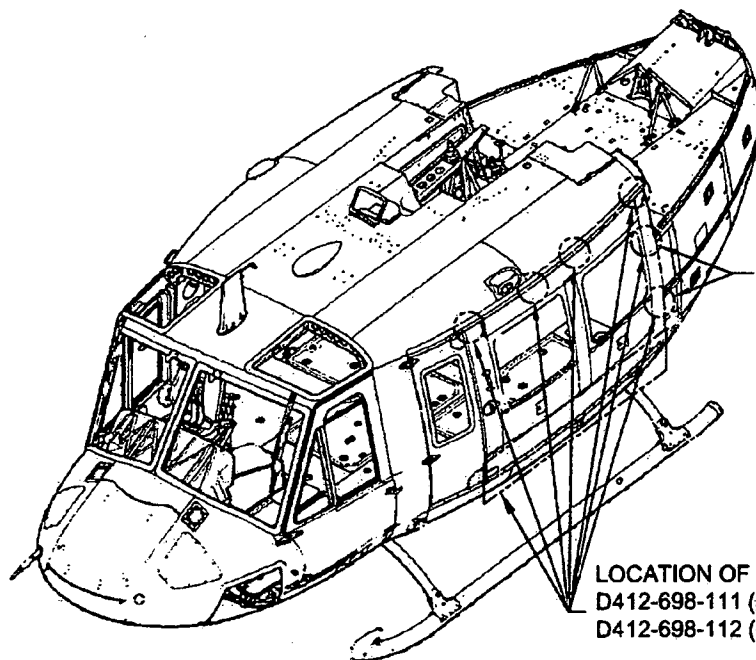
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Operator									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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LOCATION OF
DSI 9635-011 (SHOWN)
DSI 9635-012 (OPPOSITE)

LOCATION OF
D412-698-111 (SHOWN)
D412-698-112 (OPPOSITE)

FIGURE 1 – INSTALLATION OVERVIEW

3.0 INSTALLATION

- 3.1 Remove LH and/or RH sliding doors (ref P/N 205-031-669-15/-16) from the aircraft per the Aircraft Maintenance Manual.
- 3.2 Remove 205-031-436-001 and replace with D3121-141 Bracket (3 places). Reuse existing hardware and shims if determined to be airworthy. Alternatively, if using D412-698-021 Replacement Shim Kit, install D3238-1 & D3238-11 as required. Note that the D3121-141 brackets contain one additional middle slot not used for this installation (see Figure 6 of IIN-D412-698 or Figure 52-8 of ICA-D412-698).
- 3.3 Remove 205-031-435-001/002 and replace with D3121-143 Bracket for left hand doors and D3121-144 Bracket for right hand doors. Reuse existing mounting hardware and shims if determined to be airworthy. Alternatively, if using D412-698-021 Replacement Shim Kit, install D3238-3 & D3238-13 as required. Note that the D3121-143/-144 brackets contain one additional middle slot not used for this installation (see Figure 6 of IIN-D412-698 or Figure 52-8 of ICA-D412-698).
- 3.4 Remove 205-031-433-1 Roller Support (LH) and 205-031-433-2 Roller Support (RH) and replace with D4737-043 on left hand doors and D4737-044 on right hand doors. Reuse existing mounting hardware and shims if determined to be airworthy. Alternatively, if using D412-698-021 Replacement Shim Kit, install D3238-5 & D3238-15 as required.

NOTE: The upper aft door track on early model aircraft may not have been modified to accept the extra roller on the D4737-043/-044 Brackets. If this track has not been modified, it should be modified in accordance with BHT TB 205-99-105 at this time.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 13.01.11
CERT. NO.: SH92-43
ISSUE NO.: 5

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9635	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ROLLER BRACKET CHANGE KIT	NTS
DATE	13.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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- 3.5 Remove 205-031-434-1 Roller Support and replace with D4737-041. Reuse existing mounting hardware and shims if determined to be airworthy. Alternatively, if using D412-698-021 Replacement Shim Kit, install D3238-5 & D3238-15 as required.
- 3.6 Remove 205-032-669-125 Track (LH) and/or 205-032-669-126 Track (RH) as applicable. Install D3199-1/-3/-4 Brackets and D3202-1 Cover as shown in Figure 2 using existing mounting hardware if determined to be airworthy.
- 3.7 Re-install LH and/or RH doors on the aircraft per the Aircraft Maintenance Manual. Check sliding operation of door. Adjust position/shimming of all new brackets until door operation is smooth and free of dragging/binding through full travel of the door. Once the door is sliding smoothly, torque all fasteners per Aircraft Maintenance Manual.
- NOTE:** To prevent roller wear and premature door track wear, ensure vertical rollers are sitting flush to door tracks.
- 3.8 **NOTE:** It is acceptable to install any portion of the D412-698-111/-112 kits in combination with the existing Bell door components. Replacement parts may be ordered individually as follows:

Bell Part Number	Location	Dart Replacement Part Number	Applicable Instruction
205-031-436-001	STA 162 in STA 140 in STA 116 in	D3121-141	3.2
205-031-435-001	STA 96 in	D3121-143	3.3
205-031-435-002	STA 96 in	D3121-144	3.3
205-031-433-1	STA 168 in	D4737-043	3.4
205-031-433-2	STA 168 in	D4737-044	3.4
205-031-434-1	STA 168 in	D4737-041	3.5

4.0 WEIGHT AND BALANCE

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-698-111 Cabin Door	0.98 lb	-48.0 in	-47.0 in lb	130 in	127.4 in lb
Roller Kits (net)	0.44 kg	-1.22 m	-0.54 m kg	3.30 m	1.45 m kg
D412-698-112 Cabin Door	0.98 lb	48.0 in	47.0 in lb	130 in	127.4 in lb
Roller Kits (net)	0.44 kg	1.22 m	0.54 m kg	3.30 m	1.45 m kg
Both D412-698-111/-112 Installed (net)	1.96 lb	0 in	0 in lb	130 in	254.8 in lb
	0.88 kg	0 m	0 m kg	3.30 m	2.90 m kg
Replace 205-031-433-1 with D4737-043 (net)	0.19 lb	-48.0 in	-9.1 in lb	168 in	31.9 in lb
	0.09 kg	-1.22 m	-0.11 m kg	4.27 m	0.38 m kg
Replace 205-031-433-2 with D4737-044 (net)	0.19 lb	48.0 in	9.1 in lb	168 in	31.9 in lb
	0.09 kg	1.22 m	0.11 m kg	4.27 m	0.38 m kg
Replace 205-031-434-1 with D4737-041 (net)	0.12 lb	+/-48.0 in	+/-5.8 in lb	168 in	20.2 in lb
	0.05 kg	+/-1.22 m	+/-0.06 m kg	4.27 m	0.21 m kg

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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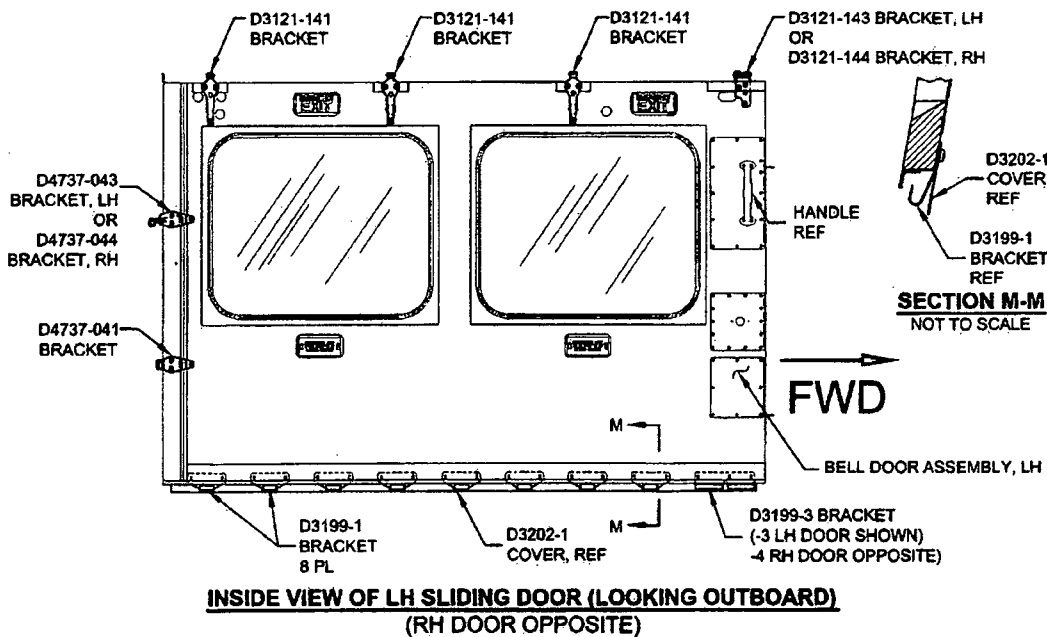
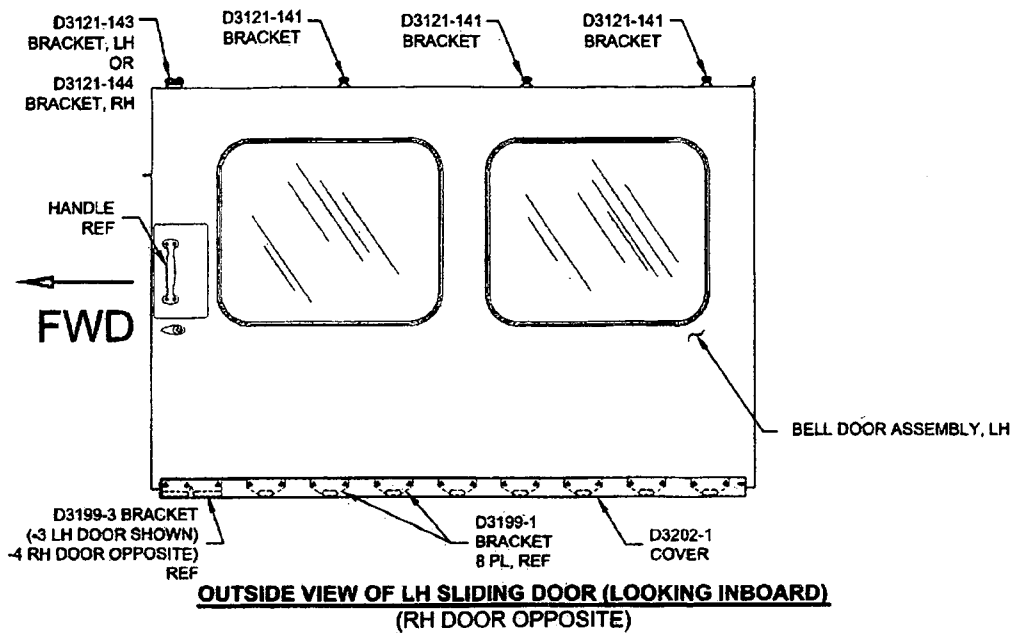


FIGURE 2 - MODIFIED SLIDING DOOR
(D412-698-111 SHOWN, D412-698-112 OPPOSITE)

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

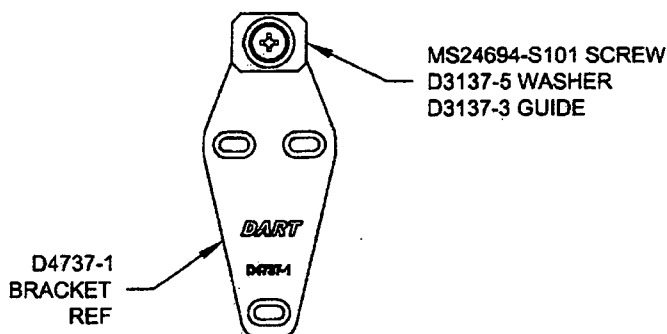
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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5.0 MAINTENANCE

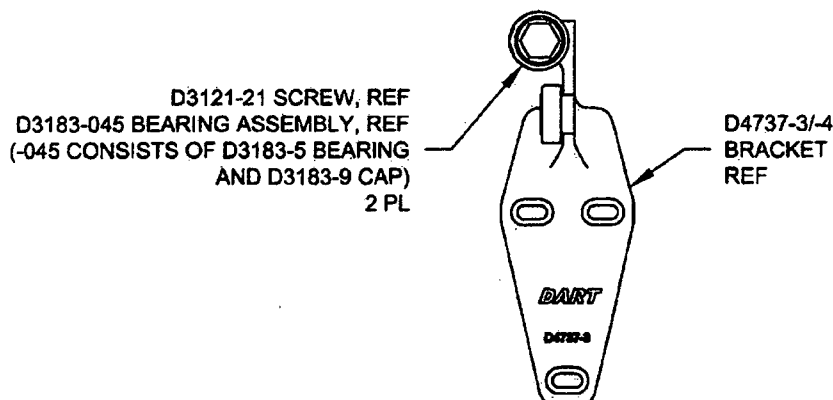
Maintain D412-698-111/-112 in accordance with ICA-D412-698 for the D412-698-011/-012 Kits.

6.0 D4737-041/-043/-044 REPLACEMENT PARTS

For D3121-141/-143/-144 Bracket Assemblies, see Section 5.0 of IIN-D412-698 (Section 52.14 of ICA-D412-698).



D4737-041 BRACKET ASSEMBLY



D4737-043/-044 BRACKET ASSEMBLY

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129171

Friday, January 30, 2015 8:52:07 AM

129171 Ship Feb 13

Page 1

Item ID: D412-698-111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Door Roller LH Aluminum Door

Start Date: 1/30/2015 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 1/30/2015 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 1501-30 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9635	B

5.0

MLS 1502-02

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-698-111 CHG002

(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

DAG
#6
9-89

JAN 31 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control